

Work Order ID 68968

Tuesday, April 26, 2011 2:22:32 PM



Page 1

Item ID: D3201-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 4/26/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

11-04-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3201

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3201

☐ Dwg Rev:

B

☐ Prog Rev:

B

☐ 2-

Debur if necessary

B-11-5-2

(15)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B-11-5-2

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sulostoz

(+15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3201-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 4/26/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

0.00

Small Fab

Memo

Debur Stack

W/A

Small Fab

8

140

0.00



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

Hand Finishing

15 d 4/05/03

150

0.00



QC3- Inspect Part Finish

0.00

QC

Memo

Quality Control

15 BR 11-5-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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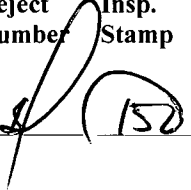

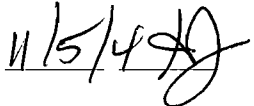
NOTE: Date & initial all entries

Work Order ID 68968

Tuesday, April 26, 2011 2:22:32 PM

Page 3

Item ID: D3201-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Doubler					
Start Date: 4/26/2011	Start Qty: 12.00		Cust Item ID:		
Required Date: 4/29/2011	Req'd Qty: 12.00		Customer:		
Reference:					
Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Start
					
					Stop
					

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging	Identify as per dwg & Stock Location: <u>YD</u> Memo	0.00 0.00				<u>11/3</u>	<u>1/3</u>	<u>150</u>	
170  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<u>11/5/4</u>	

11/1-05-3
(15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 26, 2011 2:22:37 PM

Page 1

Work Order ID: 68968



Parent Item: D3201-1



Parent Item Name: Doubler

Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-25 JLM
IPP Rev:B Now on Waterjet 06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

91.5000

0.276

3.486316

4.5



1B 11-5-2

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

91.5

112291

0.5

112331

27

113162

64

113162

15

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

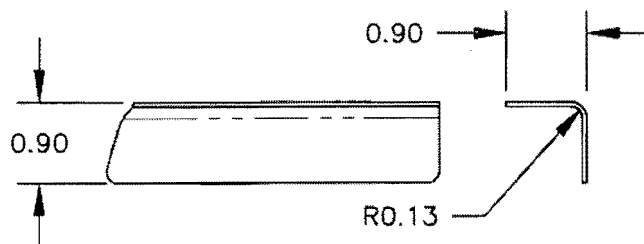
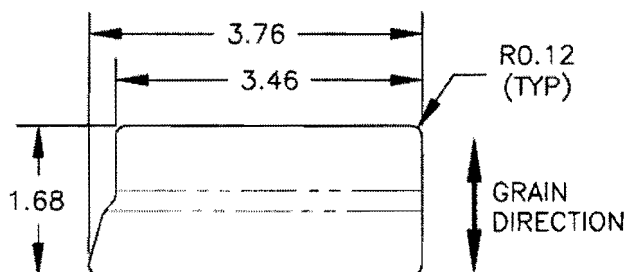
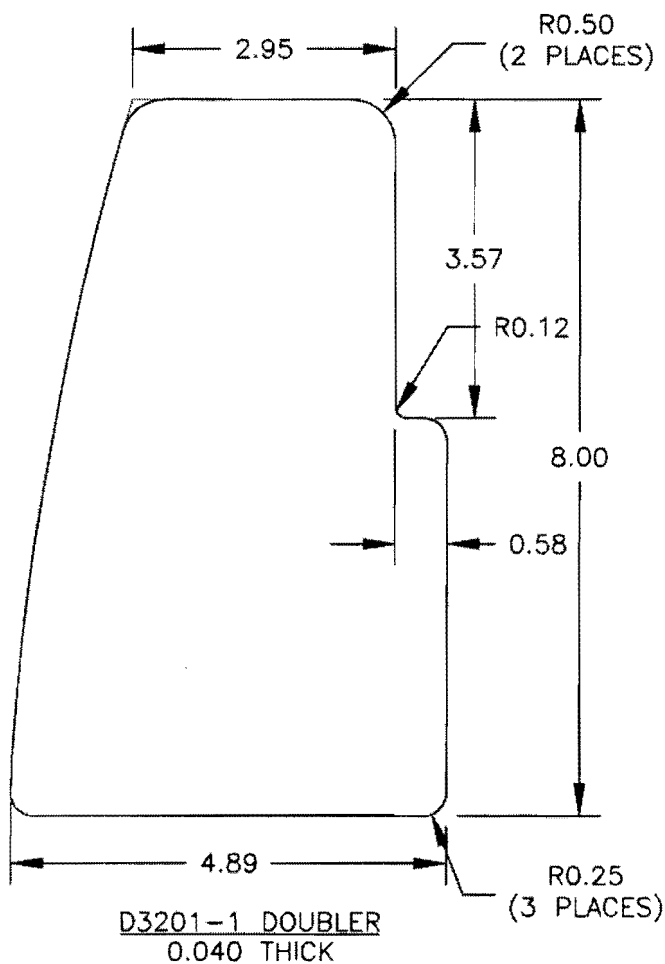
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DESIGN <i>#</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3201	REV. B SHEET 1 OF 1
DATE 03.11.03	TITLE DOUBLER		SCALE 1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

RELEASED
03.11.04



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *68968*

11-09-26

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